

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013682**Date Inspected:** 02-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Gong Wai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #14

This QA Inspector observed the following work in progress:

SMAW in the 4F position for the OBG Segment 12CE, weld No. SEG3003S-080. The welder is identified as #066179. ZPMC QC is identified as Mr. Guo Pan. The welding variables recorded by QC appear to comply with WPS-B-P-2114-FCM-1.

FCAW in the 3G position for the OBG Segment 12BE, weld No. SEG3002D-001. The welder is identified as #048038. ZPMC QC is identified as Mr. Guo Pan. The welding variables recorded by QC appear to comply with WPS-B-T-2233-B-U2-F.

FCAW in the 3G position for the OBG Segment 12BE, weld No. SEG3002E-006. The welder is identified as #206623. ZPMC QC is identified as Mr. Guo Pan. The welding variables recorded by QC appear to comply with WPS-B-T-2233-B-U2-F.

FCAW in the 3G position for the OBG Segment 12BE, weld No. SEG3002H-003. The welder is identified as #214945. ZPMC QC is identified as Mr. Guo Pan. The welding variables recorded by QC appear to comply with

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WPS-B-T-2233-B-U2-F

During in-process observations of the Corner Assembly CA6501 of segment 12AE being fabricated in bay 14, the Caltrans Quality Assurance Inspector (QA) observed that the tack weld between deck plate to stiffener has cracked. The weld numbers are identified as CA6501C-PP112-002 and CA6501D-PP111.5-11. For details see the attached photo.

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as U-rib to U-rib splice butt weld.

The Weld Designations are as follows

DP3045-001-341

DP3043-001-341

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
